Work Order ID 106927

106927

September-11-13 11:53:28 AM

Item ID: 646.3912 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Shim

Start Date: 9/23/13 **Start Qty:** 40.00 ~~*41*~~ *42* **Cust Item ID:**

Required Date: 9/23/13 **Req'd Qty:** 40.00 *40* **Customer:**

Reference:

Approvals: **Process Plan:** MCS **Date:** 13-09-11 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
646.3900	N/C								
110		0.00							
110						42	0		Ac 13.11.02
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: N/C Prog Rev: N/C 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						42	0		Ac 13.11.02
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: 646.3912 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Shim
Start Date: 9/23/13 **Start Qty:** 40.00 *40*
Required Date: 9/23/13 **Req'd Qty:** 40.00 *40*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00 DAS 27 9-89				42			
130									
QC	**Memo**	0.00 B1104							
Quality Control									
140	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
140						CL 13/11/06 42			
Outsource3	**Memo**	0.00							
Outsource process - Cad plate	Issue P/O: 21961								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150						DX 13-12-4			
Packaging	**Memo**	0.00							
Packaging									

DAS 26 9-89

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Temperature/Cure
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- ☐ Wrong Stock Pulled
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Work Order ID 106927

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September-11-13 11:53:28 AM

Item ID: 646.3912 **Accept** *N900040100* **Setup Start** *NS1*

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Item Name: Shim

Start Date: 9/23/13 **Start Qty:** 40.00 *40* **Cust Item ID:**

Required Date: 9/23/13 **Req'd Qty:** 40.00 *40* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				42			
	Memo	0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: ST035	0.00				13/12/5	(42)		DAS 32 ~~9-89~~
	Memo	0.00							
	IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV								
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					13/12/13		
	Memo	0.00							

13-12-5

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

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- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
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_____

_____

_____

Picklist Print

September-11-13 11:53:27 AM

Work Order ID: 106927

Parent Item: 646.3912 **Start Date:** 9/23/13 **Required Date:** 9/23/13

Parent Item Name: Shim **Start Qty:** 40.00 **Required Qty:** 40.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020		Purchased	No			110	sf	28.4000	**0.02**	~~0.842104~~	Ac 13.11.02		
C1095 Blue Tempered Spring Steel Sheet .020													

Location	Loc Qty	Loc Code
MAT022	28.4	
123537	5.4	
m126423	23	

126423 → .86

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	106927
Description: Shim	Part Number:	646.3912
Inspection Dwg: 646.3900 **Rev:** N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.005	1.00"	-		V	JKm-01
2.90	+/-0.005	2.90"	-		V	
0.020	+/-0.005	.020"	-		V	

Measured by:	AC
Date:	13.11.02

Audited by:	DAS 27 9-89
Date:	13/11/04

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	12.11.30	New Issue	KJ	

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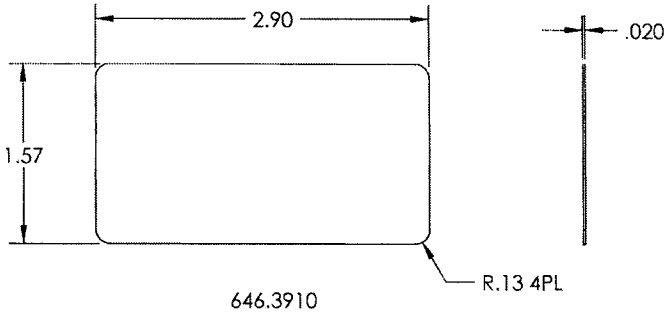
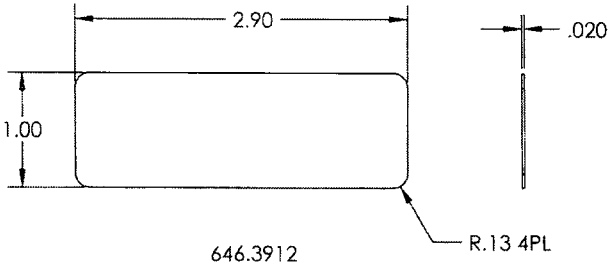
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

NOTES:

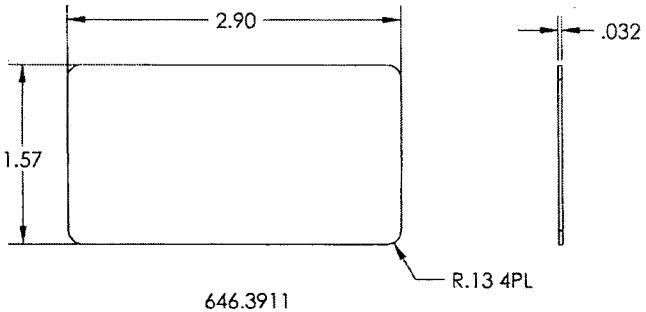
1. MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL
2. FINISH: CAD PLATE PER QQ-P-416 TYP II CL2
3. IDENTIFY IAW MPP-120



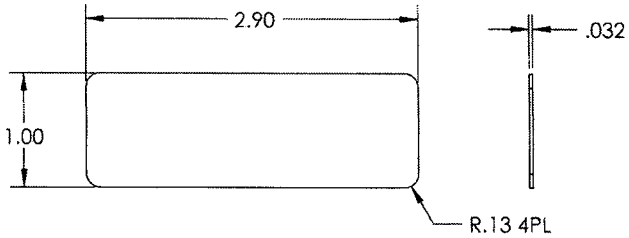
646.3910



646.3912



646.3911



646.3913

106927 MCJ
13-09-11

FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	646.3913	SHIM	1	2
	646.3912	SHIM	1	2
	646.3911	SHIM	1	2
	646.3910	SHIM	1	2

QTY | PARTS LIST

NEXT ASSY (S): 646.4000

ORIGINAL DATE (MONDAY/YR): 09-03-08
DRAWN BY: S. HUFF
CHECKER: P. BRAVO
DRAWING APPROVAL: P. BRAVO 09-03-08
CONTRACT NO.:

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ± 2°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SHIM

SIZE: B | CAGE CODE: 07M26 | DWG. NO.: 646.3900 | REV.: N/C
SCALE: NONE | SHEET 1 OF 1

CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1

DATE: Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 130252

INVOICE #: 68742

CONTRACT OR PURCHASE ORDER # PO21961

DESCRIPTION: SHIM **QTY** 42

P/N # 646.3912 **S/N #** 106927

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2.
BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

CI 22

Approved Inspector: _____